

Work Order ID 73750

Wednesday, September 14, 2011 12:08:16 P



Page 1

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 9/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10914

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3293	Rev A

100



FLOW WATER JET

Waterjet

Memo

0.00

B11-9-28

FLOW CNC Waterjet

2024.08

I-Cut as per Dwg D3293 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

B11-9-29

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

0.00

Sept/28



Quality Control

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73750

Wednesday, September 14, 2011 12:08:16 P



Page 2

Item ID: D3293-1

Accept



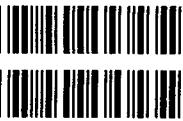
Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 9/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Small Fab

Operation
Description

Small Fab

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

1- Deburr

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

0.00

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

8 BK 11-9-28.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73750

Wednesday, September 14, 2011 12:08:16 P



Page 3

Item ID: D3293-1

Accept



Setup

Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 9/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Powdercoat

Powder Coating

170



QC

Quality Control

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

3:15

0.00

Memo

START TIME:

3200

OVEN TEMPERATURE:

345

FINISH TIME:

3:45

8X Øm. 11/09/29

180



QC3- Inspect Part Finish

0.00

Memo

0.00

8 Ø 11/09/29
counted

Identify as per dwg & Stock Location: 21

0.00

Memo

0.00

8 Ø 11/09/29
Cup/Bu Ø

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73750

Wednesday, September 14, 2011 12:08:16 P



Page 4

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 9/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

W/10/3
MF

11-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 14, 2011 12:08:13 PM

Page 1

Work Order ID: 73750



Parent Item: D3293-1



Parent Item Name: Doubler

Start Date: 9/14/2011

Required Date: 9/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: A 04.08.24 New issue KJ/JLM
IPP Rev:B Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	197.3000	1.8264	15.38021		11-9-28	

2024-T3 .080 sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	197.3	
105411	6	
109424	4	
110347	0.5	
112331	3	
113796	7	
114025	15.7	
116604	5.8	
117392	40.1	
118180	115.2	118180

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73750
Description: Doubler	Part Number:	D3293-1
Inspection Dwg: D3293	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

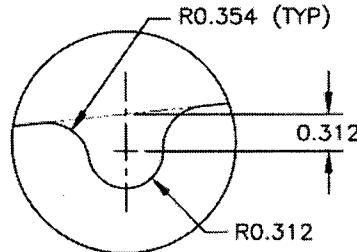
X First Article Prototype

Measured by: <u>W</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>11-9-09</u>	Date: <u>11/09/09</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	08.10.09	0.080 dimension added	KJ/DD	

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 2004 by DART AEROSPACE LTD



DETAIL A
SCALE 2:3

RELEASE
04.07.12

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY
MATERIAL: 2024-T3 (2024-T3) SHEET, 6.000 THICK

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK
FINISH: ACID ETCHED AND ALGINATE PEP. PART: 621-025-44

FINISH: ACID ETCH AND A
POWDER COAT BL

POWDER COAT BLACK SANOTEX (REF. 4.3.5.7) PER
DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

A circular stamp with the text "OACOPY IS ISSUED" arranged in a circle.

DART AEROSPACE LTD <small>HAWKESBURY, ONTARIO, CANADA</small>		
DESIGN		
CHECKED		
W		
APPROVED		
W		
DRAWN BY		
W		
DRAWING NO.		
D3293		
SHEET 1 OF 1		
TITLE		
DOUBLER		
DATE		
04.06.28		
SCALE		
1:3		
A		
04.06.28		
REV. A		

